

Date: Monday, 7/16/2007 2:42:24 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BO 105 SKID TUBE 'I' BEAM
Job Number : 33545	
Estimate Number : 11075	
P.O. Number : <i>N/A</i>	Part Number : D2976
This Issue : 7/16/2007 S.O. No. : <i>N/A</i>	Drawing Number : D2976 REV A1
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : LANDING GEAR	Drawing Revision : A1
Previous Run : 27742	Material : <i>N/A</i>
Written By : _____	Due Date : 7/23/2007 Qty: 3 Um: Each
Checked & Approved By : <i>DP 07.07.17</i>	
Comment : Est. C 02.10.30 Re-format KJ	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2963084	105 I Beam Extrusion
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Comment: Qty.: 4.5938 Each(s)/Unit Total : 13.7813 Each(s)
Extrusion 'I Beam' thin
Pick:

Qty	Part Number	Description	Batch
1	D2963-084	Extrusion	<i>B14459 DP 7-7-19</i>

2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1
Cut D2963-084 extrusion to length: (82.00")
Use Jig DT8546 to drill pilot holes
Open holes to finish size per dwg D2976
Deburr

DP 7-7-19

3.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1
Acid etch and Alodine as per QSI 005 4.1

07/07/30 ANM

4.0	QCS	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

En 07/07/31 (13)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: *LG BE 07-07-31*

DP

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Drawing Name: BO 105 SKID TUBE 'I' BEAM

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Part Number: D2976

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(3)

Comment: FINAL INSPECTION/W/O RELEASE

12/08/01

Job Completion

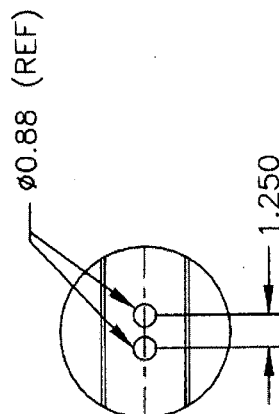
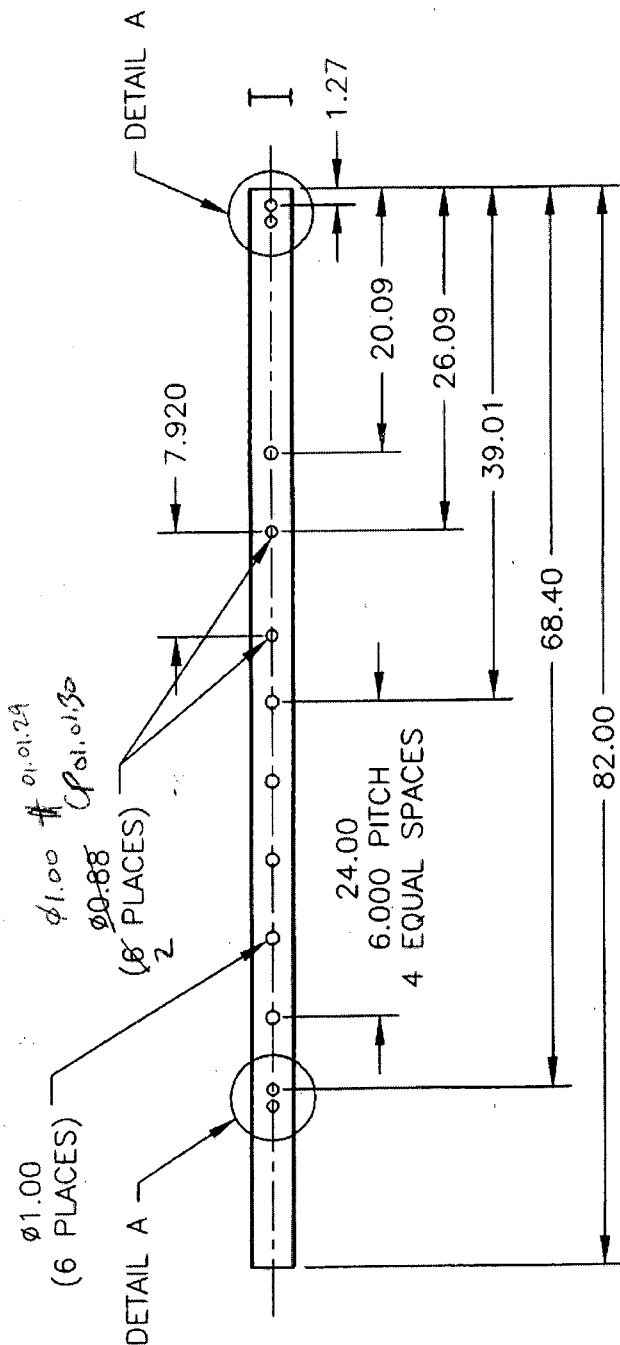


4/07-07-31



DESIGN RF	DRAWN BY RF	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED #	APPROVED #	DRAWING NO. D2976	REV. A SHEET 1 OF 1
DATE 00.03.14	TITLE WEB		SCALE 1:14
A	00.03.14	NEW ISSUE	
AI	01.01.29	OPEN GROUND HANDLING HOLES TO $\phi 1.00$	

RELEASED
00.05.11 #



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 33545

MAKE FROM D2963-084 EXTRUSION
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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